

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018056**Date Inspected:** 05-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 204342 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002J-001-307,308. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as 204342 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002J-002-307,308. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as 051246 / 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002A-018-008,026. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) lift 14E Deck Panel; this QA inspector discovered the following issues. ZPMC personnel performed heat straightening of lift14E deck panel. ZPMC did not follow the heat straightening procedure HSR (B) - 9707. ZPMC personnel mounted a temporary fixture and drove unidentified steel wedges between the fixture and SPCM material. The SPCM steel plate is identified as RS3266A. The affected Deck Panel is identified as DP3165-001. The material is A709 Grade 345 Seismic Performance Critical Member (SPCM). This QA notified ZPMC QA identified as Mr. Zhang Wei of this issue and that an incident report would be generated. For further information, please see the attached pictures below.

## OBG # BAY 7

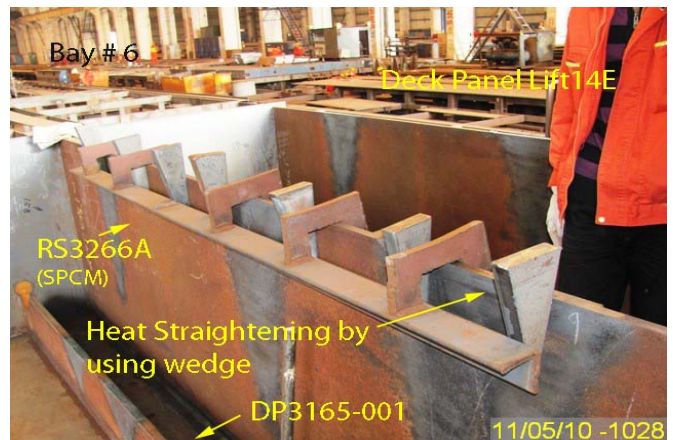
This QA observed ZPMC qualified welding personnel identified as 048625 perform Flux Cored Arc Welding (FCAW) Process on weld joint W2-SB10-026-057,058,059,060. ZPMC Quality Control Personnel (QC) identified as Mr. Wang liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 215689 perform Flux Cored Arc Welding (FCAW) Process on weld joint W2-SB10-028-057,058,059,060. ZPMC Quality Control Personnel (QC) identified as Mr. Wang liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

## OBG # BAY 8

This QA observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A6-044-043,162,021,158. ZPMC Quality Control Personnel (QC) identified as Mr. Liu fa wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

As mention above

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Sukanthan,Dhanasingh
----------------------	----------------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Hall,Steven
---------------------	-------------

QA Reviewer
-------------